

Work Order ID 82228-1

82228

Page 1

March-27-12 7:59:54 AM

Item ID: D2893-1

Revision ID:

Item Name: 2.75 Support

Start Date: 27/03/2012 Start Qty: 20.00

Required Date: 04/05/2012 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: MCT

QC:

Date: 12/03/12 Tooling:

Date: SPC (Y/N):

N9000040100

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2893

C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA081
2-Deburr

8

0

12/04/09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8

0

12/04/09

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8

0

12/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 82228

82228


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March-27-12 7:59:54 AM

Item ID: D2893-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 2.75 Support
 Start Date: 27/03/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 04/05/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/12 

12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-27-12 7:59:57 AM

Page 1

Work Order ID: 82228

82228

Parent Item: D2893-1

D2893-1

Parent Item Name: 2.75 Support

Start Date: 27/03/2012

Required Date: 04/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.26Reformat: Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	20.0000	0.5	10.52632			

DSK078

D2893-1 TURNING DETAIL

**

10

St 12/04/08

Location

Loc Qty

Loc Code

MAT

-10

MAT060

30

80157

20

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	82228
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.992	2.990	2.993	2.993	2.993
AB	0.440	0.460		0.4405	.445	.445	.455	.445
AC	0.125	0.160		0.130	.136	.135	.135	.135
AD	0.040	0.060		0.052	.048	.052	.048	.050
AE	0.188	0.193		0.190	.190	.190	.190	.190
AF	0.125	0.160		0.145	.145	.145	.145	.145
AG	0.140	0.160		0.146	.153	.153	.152	.155
AH	1.360	1.400		1.3745	1.3745	1.375	1.378	1.373
AI	0.040	0.060		0.049	.050	.046	.052	.050
AJ	1.190	1.230		1.218	1.220	1.215	1.2185	1.218
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		0.063	.063	.063	.063	.063
AM	0.240	0.260		0.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.528	2.530	2.531
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	.261	.261	.261	.261
AQ	0.053	0.073		0.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	12/04/08	Date:	12/04/08
Audited by:	BK	Date:	12/04/09
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

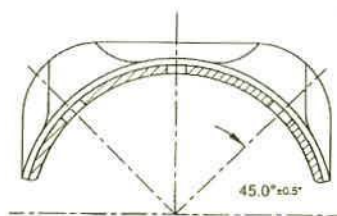
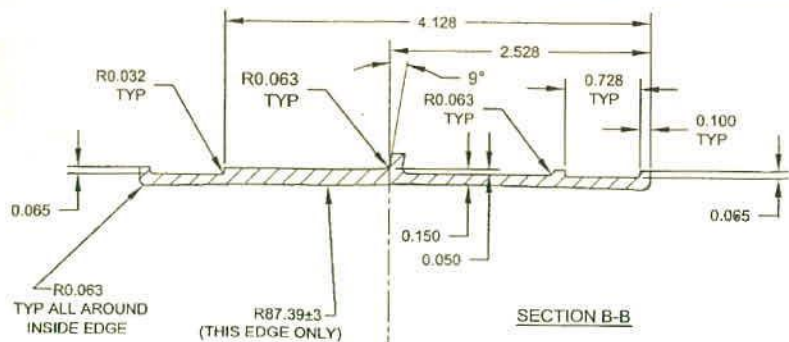
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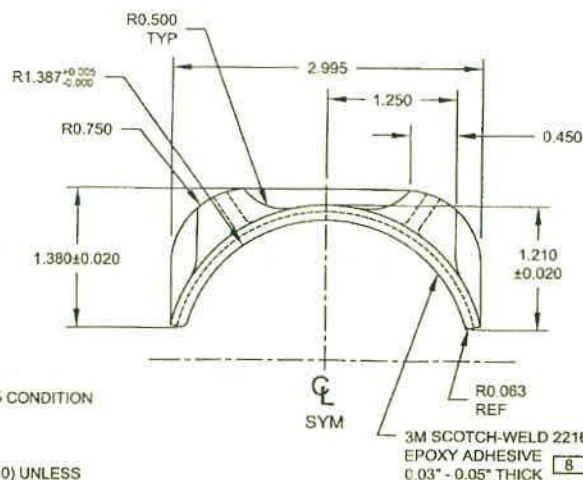
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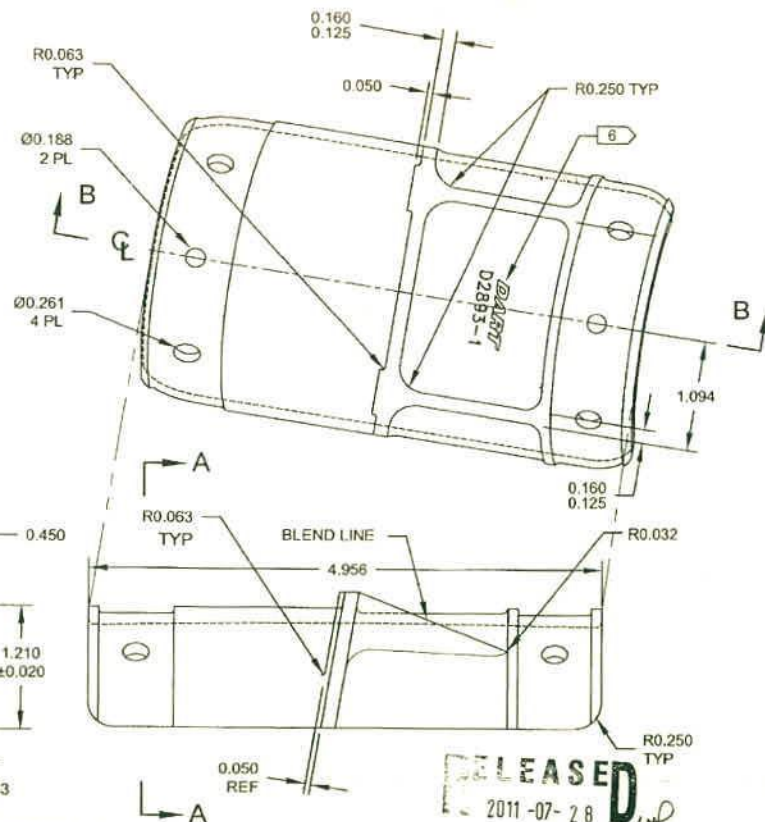
NOTE: Date & initial all entries



SECTION A-A
TOOLING HOLE DETAIL



D2893-1 SUPPORT



NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.78 lb

8) FOR THE ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER, REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

RELEASED
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED	ASS		
MFG APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2893
TITLE Ø2.750 SUPPORT
REV. C
SHEET 1 OF 1
SCALE
NTS

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SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 82228 MJS

12/03/27

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DART AEROSPACE LTD		Work Order: 82228
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6x	7x	8x	9x	10x
HAAS Section								
AA	2.985	3.005		2.994	2.994	2.994		
AB	0.440	0.460		.460	.455	.455		
AC	0.125	0.160		.139	.138	.138		
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AE	0.188	0.193		0.190	.190	.190		
AF	0.125	0.160		0.143	.140	.142		
AG	0.140	0.160		.155	.152	.155		
AH	1.360	1.400		1.371	1.370	1.371		
AI	0.040	0.060		.048	.052	.050		
AJ	1.190	1.230		1.213	1.214	1.214		
AK	0.010	0.020		.015	.015	.015		
AL	0.053	0.073		.063	.063	.063		
AM	0.240	0.260		.250	.250	.250		
AN	2.518	2.538		2.530	2.530	2.532		
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AP	0.261	0.266		.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063		
AR								
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Measured by: <i>JS</i>	Date: 12/04/09
Audited by: <i>EC</i>	Date: 12/04/09
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